Thursday, 8/23/2007 11:53:20 AM Kim Johnston User **Process Sheet** : FUEL PURGE CANISTER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 34242 Job Number : 10440 Estimate Number : D3262041 Part Number P O Number :101A S.O. No. : NO. D3262 REV C 8/23/2007 **Drawing Number** This Issue N/A Prsht Rev. Project Number : MACHINED PARTS Type **Drawing Revision** First Issue : 33065 Material Previous Run Each : 9/3/2007 Qty: **Due Date** Written By Checked & Approved By : Est. Removed P/O for liquid penetrant inspection K C 05.03.10 Comment J/JLM **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: FUEL PURGE CANISTER 1.0 34242A Comment: Sub-Component FUEL PURGE CANISTER D3262-1 B 3065 A 2.0 34242B Comment: Sub-Component FUEL PURGE CANISTER D3262-3 B 29937 3.0 Comment: LARGE FABRICATION RESOURCE 1 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Part Number **A/R** Aluminum Rod DO NOT USE Comment: WELD INSPECTION Pressure test as per Dwg D3262 HAND FINISHING RESOURCE #1 5.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	EP PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		·								

Part No: \(\sum_{\text{3060}} - 041 \) PAR #: \(\text{NA} \) Fault Category: \(\text{100} \) \(\text{fixe, ps} \) NCR: \(\text{ves} \) No DQA: \(\text{QA: N/C Closed: } \) Date: \(\text{07.11.19} \)

NCR:	301243	WC							
		Description of NC		Corrective Action Section B	. 1 - 10.00	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
0711.14	4.0	3 parts Scrap. Threading on D3862-3 caps are off center and VERY crocked R.C. operator error when topping	,	Sevapi clestral +1 D'3262-3 B25537 Venty remaincles of	EF 07/11/16	<u>.</u> 4			
		R.C. operator error when	651412	D3262-3, B29932 CAPS Findings: 6 + 633065	12-11-16	07/11/14	651042	104-11-16	
		+677.09		ir 03262-36277325crap					
								:	
								8. •	

Thursday, 8/23/2007 11:53:20 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: FUEL PURGE CANISTER Customer: CU-DAR001 Dart Helicopters Services Job Number: 34242 Part Number: D3262041 Job Number: Description: Seq. #: **Machine Or Operation:** POWDER COATING POWDER COATING 6.0 Comment: POWDER COATING 1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 2-Ensure to mask threads INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N as per Dwgasing a permanent fine point marker, then Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 11 8-11-16

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Dart Ae	rospace L	td											
W/O:			WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector					
								:					
Part No		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQA :	Date: _						
					QA: N	/C Closed:	Date: _	<u> </u>					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	R)							
		Description of NC		Corrective Action Section	on B	Verification	Ammental	A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	ription Sign & Section C		Approval Chief Eng	Approval QC Inspector					

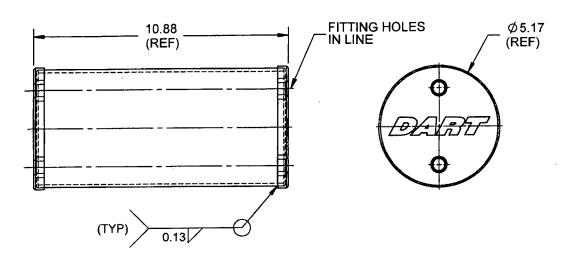
		Description of NC		Corrective Action Section I	3	Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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	DESIGN DRAWN BY		BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHEC	KED	APPRO	VED.	DRAWING NO.	REV. C			
	0	PH D3262		SHEET 1 OF 2					
	DATE	E			TITLE	SCALE			
		06.0	08.31		FUEL PURGE CANISTER	1:4			
_	REV		DATE		DESCRIPTION				
	A		04.05.06		FIRST ISSUE				
	В		05.02.14		ADD PRESSURE TESTING OPTION				
	C		06.08.31		Ø5.165 WAS Ø5.190				

RELEASED 06.04.19



D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	Х	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

1) WELD PER DART QSI 004

2) BREAK ALL SHARP CORNERS 0.005 TO 0.010

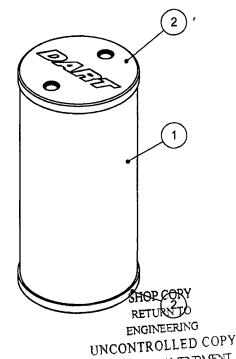
3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



WITHOUT NOTICE WORK ORDER NO.=

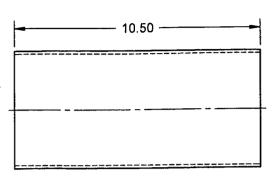
SUBJECT TO AMENDMENT

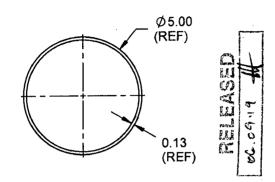
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7	13		HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO.	REV. C					
PH	-{ 	D3262	SHEET 2 OF 2					
DATE		TITLE	SCALE					
06	.08.31	FUEL PURGE CANISTER						





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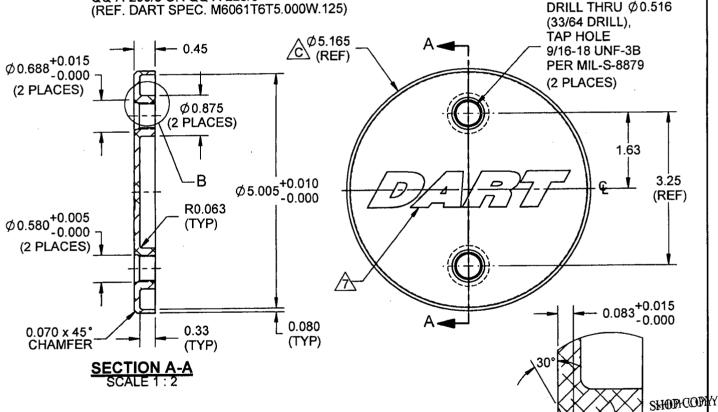
DETAIL BYO 21/24/6 SCALE 2:1

WITHOUTINGTICE

D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8

(REF. DART SPEC. M6061T6T5.000W.125)



D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)

NOTES: 2) FINISH: NONE

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

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 $R0.02^{+0.02}_{-0.00}$

R0.02^{+0.00}_{-0.01}

Drawing Name

Part Number

Drawing Number

Project Number

Date

Thursday, 8/23/2007 11:53:24 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 34242B

Estimate Number

: 10442

P O Number This Issue

: 8/23/2007

: NC

Prsht Rev. : // First Issue

Previous Run

: 33065B

Type

: MACHINED PARTS

Drawing Revision Material

Due Date

: 9/3/2007

: D32623

: N/A

: C

D3262 REV C

: FUEL PURGE CANISTER

Qty:

8 Um:

Each

Written By

Checked & Approved By Comment

C 95.03.10 : Est.

Removed P/O for liquid penetrant inspection K

J/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Bar .50" x 6.0"

1.0

2.0

M6061T6B0500X06000

7.7347 f(s) 0.9668 f(s)/Unit Total:

Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick

(M6061T6B0.500x06.000) Identify for D3262-3

Batch: M 10685

BAND SAW

BAND SAW

Comment: BAND SAW

Comment: Qty.:

Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262

Identify for D3262-3

Deburr

HAAS1

HAAS CNC VERTICAL MACHINING



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per dwg D3262

INSPECT PARTS AS THEY COME OFF MACHINE

08/01/3

4.0

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart	Aer	osp	ace	Ltd
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W/O:			WORK ORDER CHANGES										
DATE	STEP	STEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No):		PAR #:	Fault Category:	NCR: Yes	No DQ	A: É	Date: ₹	m 60/80				

QA: N/C Closed: ____ Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
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Thursday, 8/23/2007 11:53:24 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: FUEL PURGE CANISTER Customer: CU-DAR001 Dart Helicopters Services Part Number: D32623 Job Number: 34242B Job Number: Description: Seq. #: Machine Or Operation: SECOND CHECK QC8 5.0 (8) Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock BARCLAY Location: 7.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 2008h loi (8 Job Completion

Dart Aerospace Ltd

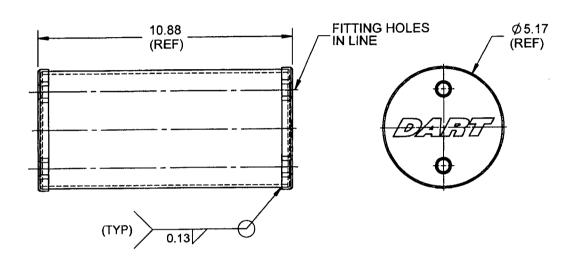
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Part No	•	PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date:				
					QA:	N/C Close	d:	Date: _				
NCR:			WORK ORDER NON-COM	IFORMANCE	(NC	R)	 -					
			Corrective Actio	n Section B					I			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B				Annroyal	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		



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	0	PH	-/ /	-	D3262	SHEET 1 OF 2
	DATE				TITLE	SCALE
		06.0	8.31		FUEL PURGE CANISTER	1:4
_	REV		DATE		DESCRIPTION	
	A	(4.05.06	1	FIRST ISSUE	
	В	(5.02.14		ADD PRESSURE TESTING OPTION	
	С	(6.08.31		Ø5.165 WAS Ø5.190	

06.09.19 #



D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	Х	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES

1) WELD PER DART QSI 004

2) BREAK ALL SHARP CORNERS 0.005 TO 0.010

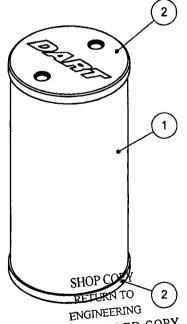
3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO B CHECK FOR LEAKS

4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

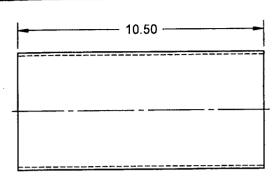
WORK ORDER NO 34242 E

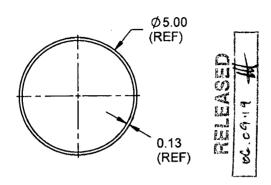
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DESIGN	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CANA	
CHECKED PH	APPROVED	DRAWING NO.	REV. C SHEET 2 OF 2
DATE 06	.08.31	TITLE FUEL PURGE CANISTER	SCALE 1:4





D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR

QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T5.000W.125)

DRILL THRU Ø0.516 (33/64 DRILL). TAP HOLE Ø5.165 (REF) - 0.45 9/16-18 UNF-3B PER MIL-S-8879 (2 PLACES) (2 PLACES) Ø0.875 (2 PLACES) 1.63 Ø 5.005 +0.010 -0.000 3.25 (REF) R0.063 $\phi_{0.580}^{+0.005}_{-0.000}$ (TYP) (2 PLACES) $0.083^{+0.015}_{-0.000}$ 0.080 0.33 0.070 x 45° (TYP) CHAMFER (TYP) SECTION A-A SCALE 1:2 D3262-3 CAP R0.02^{+0.02}_{-0.00}

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)

NOTES: 2) FINISH: NONE

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEDENGINEERING
 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED NOTED COPY
 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010 PART IS SYMMETRICAL ABOUT CENTERLINE

SUBJECT TO AMENDMENT

SHOP COPO 00 RETURN TO 01

7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP WITHOUT NOTICE (MAX) LETTERS WITH TOOL PADULE OF 0.05 (1977) (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

WORK ORDER

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DART AEROSPACE LTD	Work Order: 34242	
Description: FUEL PURGE CANISTER	Part Number: D3262-	3
Inspection Dwg: 032/,2 Rev: ()	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

.•	.,,,	First Article Pr			Prototype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	ments		
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Measured by:		Date:	· · · · · · · · · · · · · · · · · · ·			Date:			
Date:		Date.				wined by	Approved		
Rev Date	Change				KJ KJ	vised by /RF	Approved		
Α	New Issue	<u>.</u>			``				

DART AEROSPACE LTD	Work Order:	36777
DART AERUSPACE LID		· · · · · · · · · · · · · · · · · · ·
	Part Number:	03262-3
Description: CAP		<u>.</u>
		Page 1 of 1
Inspection Dwg: [) 32(2) Rev: C		

FIRST ARTICLE INSPECTION CHECKLIST

	X First Article Prototype					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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. 0 50	±-010	077				
R.063	±.010	R.063				
80.575	±.010	8.875		 		
85.005	+:600	Ø5.007		 		
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85.165	t.010 +.068	\$5.166				
EC. 516	<u> </u>	80.520				
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••			Audited by:	Prototype Approval:	
Measu	red by:	Tul	Additional	Date:	
_	Date:	08/02/02	Date: 4803.02	Date.	
L				Revised	by Appr
Rev	Date	Change		KJ/RF	
Α		New Issue			

Dart Aerospace Ltd. Thursday, 8/23/2007 11:53:22 AM Date: Kim Johnston **Process Sheet** : FUEL PURGE CANISTER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 34242A : 10441 **Estimate Number** : D32621 Part Number : NA P O Number S.O. No. : NA : D3262 REV C **Drawing Number** 8/23/2007 This Issue : N/A Project Number Prsht Rev. MA : MACHINED PARTS : C Type **Drawing Revision** First Issue : 33065A Material Previous Run : 9/3/2007 **Due Date** Written By Checked & Approved By Removed P/O for liquid penetrant inspection K C 05.03.10 : Est. Comment J/JLM **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: M6061T6T5000W125 6061-T6 Tube 5.00X.125W 1.0 Comment: Qty.: 3.7624 f(s) 0.9406 f(s)/Unit Total: Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: 17/1655 2.0 BAND SAW BAND SAW Comment: BAND SAW Cut D3262-1 to length as per Dwg D3262 Identify as D3262-1 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 3.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

Comment: SECOND CHECK

QC8

5.0

Each

Dart Aerospace	L	td
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
•											
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A: <u></u>	Date: _‹	2/10/08				
			QA: I	N/C Close	d:	_ Date: _					
		WORK OPPED NON CON	FORMANICE (NO	71							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Verification	Approval	AI				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto		
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Date:

Thursday, 8/23/2007 11:53:22 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 34242A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 164



7.0

QC21





Job Completion



Le 84-1025

Dart Aerospace Ltd

		WOR	ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGI	:	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No		PAR #: Fault Category	: NC	R: Yes	No DC	A:	Date: _	
				QA:	N/C Close	ed:	Date: _	

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
-		Description of NC		Verification				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
							-	

DART AEROSPACE LTD	Work Order:	34242A
Description: Tube	Part Number:	D3262-1
Inspection Dwg: D3262 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	>	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
10.50	+/-0.030	10.508					
	*						
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	1 1						
Measured by:	11	Audited by:	~ / /		Prototype App		N/A
Date:	-/2	Date:	A 2/1	A2		Date:	N/A

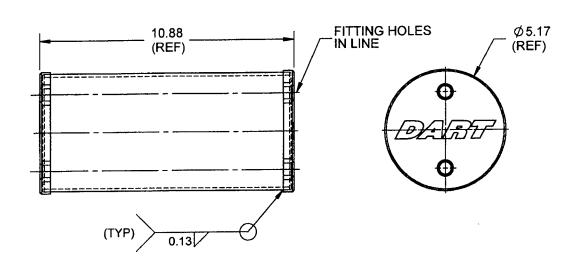
	Date:	03/1023	Date: 08/0/23	Date:	N/A
Rev	Date	Change		Revised by	Approved

Rev	Date	Change	Revised by	Approved
Α	06.05.24	New Issue	KJ/JLM 1.A	
В	06.12.14	Dwg updated to Rev. C	KJ/JLM o	Z



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	DESIGN DRAWN E		BY 3	DART AEROSPACE L HAWKESBURY, ONTARIO, CAMA		
	CHEC	KED	APPRO	ζED	DRAWING NO.	REV. C
	0	PH	-//	H	D3262	SHEET 1 OF 2
	DATE				TITLE	SCALE
		06.0	08.31		FUEL PURGE CANISTER	1:4
_	REV		DATE		DESCRIPTION	
	Α	. (04.05.06		FIRST ISSUE	
	В	(05.02.14		ADD PRESSURE TESTING OPTION	
	С		06.08.31		Ø5.165 WAS Ø5.190	

RELEASED 06.04.19



D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	Х	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES: 1) WELD PER DART QSI 004

2) BREAK ALL SHARP CORNERS 0.005 TO 0.010

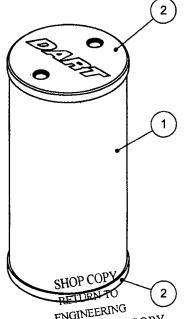
3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

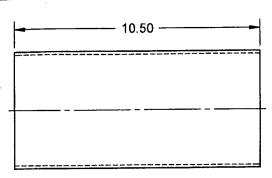


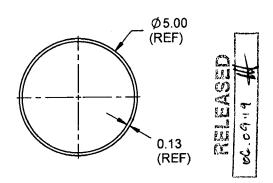
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WORK ORDER



DESIGN	DRAWN BY	DART AEROSPACE	LTD
 	_A	HAWKESBURY, ONTARIO, CAN	ADA
CHECKED	APPROVED	DRAWING NO.	REV. C
PH	- #-	D3262	SHEET 2 OF 2
DATE		TITLE	SCALE
06	.08.31	FUEL PURGE CANISTER	1:4





D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8

DRILL THRU Ø0.516 (REF. DART SPEC. M6061T6T5.000W.125) (33/64 DRILL), TAP HOLE Ø5.165 (REF) - 0.45 9/16-18 UNF-3B $\phi_{0.688}^{+0.015}_{-0.000}$ PER MIL-S-8879 (2 PLACES) (2 PLACES) Ø0.875 (2 PLACES) 1.63 3.25 Ø5.005+0.010 -0.000 (REF) R0.063 ϕ 0.580 $^{+0.005}_{-0.000}$ (TYP) (2 PLACES) $0.083^{+0.015}_{-0.000}$ 0.080 0.070 x 45° 0.33 CHAMFER (TYP) (TYP) SECTION A-A SCALE 1:2

D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)

- NOTES: 2) FINISH: NONE
- RF0.02 F0.00 ENGINEER 0:01 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NTROLLED COPY
 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED NOTED NOTED TO AMENDMENT
 5) BREAK ALL SHAPP COPNIEDS 2005 TO 2005 SUBJECT TO AMENDMENT
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010

6) PART IS SYMMETRICAL ABOUT CENTERLINE 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

WITHOUT NOTICE WORK ORDER

R0.02^{+0.02} SHOP COP 0.00

DETAIL B SCALE 2:1

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